

Work Order ID 53515

November 6, 2009 4:10:37 PM



Page 1

Item ID: D3845-1KIV

Accept



Setup Start



Revision ID: B

Stop



Item Name: Hat Bin-Ivory

Start Date: 06/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 17/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 09-11-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Machine set up

2- Cut sheet to required blank size

[Signature] 09/11/10
(X3)

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3845 and folio (FTA9255 Prototype) using tool DT 9255

Dwg. Rev. C.
Folio Rev. B.

[Signature] 09/11/11
(X3)

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140		0.00							
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1) Trim to Finished Dimensions								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3845-1 KIV PAR #: _____ Fault Category: Thermal Degrading NCR: (Yes) No DQA: [Signature] Date: 05-11-24
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 05-11-24

NCR: <u>53515</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/11/11</u>	<u>180</u>	<u>Formed unit had a blister line Humidity in sheet RC process</u>	<u>[Signature]</u> <u>osum2</u>	<u>Scrap & Replace. Ensure proper drying of sheet.</u>	<u>[Signature]</u> <u>09/11/11</u>	<u>S</u> <u>02/11/18</u>	<u>[Signature]</u> <u>osum2</u>	<u>S</u> <u>02/11/18</u>
				<u>M# 110426</u>				

NOTE: Date & initial all entries

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Required Date: 17/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							<u>Ph 09/11/11</u>
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>802/11/18</u>
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							<u>9/11/18</u>

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Accept



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Cust Item ID:

Required Date: 17/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

2

09/11/19 HJ

PR 09-11-19 (2)

Picklist Print

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Page 1

Work Order ID: 53515

Parent Item: D3845-1KIVRevB

Parent Item Name: Hat Bin-Ivory

Comments:

Start Date: 06/11/2009

Required Date: 17/11/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.125-P3- 62015		Purchased	No			100	sf	1,066.770	24.0211			



6185 KYDEX .125"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1066.77

110426

1066.77

x3

OK 09/11/11

DART AEROSPACE LTD		Work Order:	53515
Description: Hat Bin		Part Number:	D3845-1KIV/KGY
Inspection Dwg: D3845	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>DL</u>	Date: <u>09/11/11</u>
------------------------	-----------------------

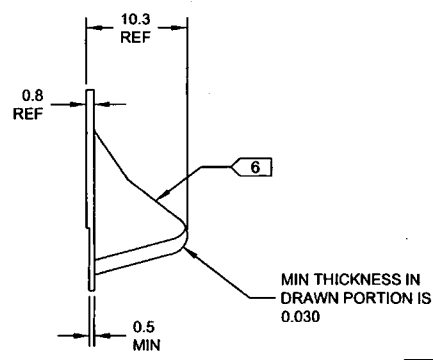
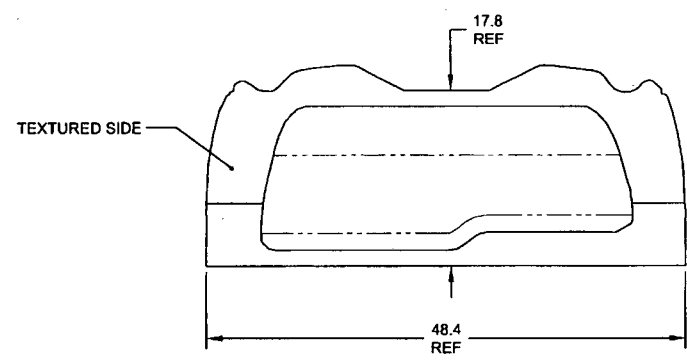
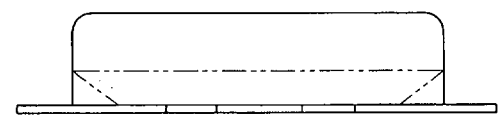
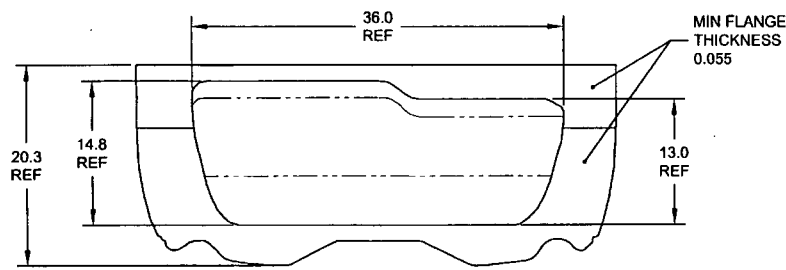
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	.531"	✓			
0.055	Min	.096"	✓			
0.030	Min	.047"	✓			

Measured by: <u>W. L.</u>	Date: <u>09/11/11</u>
Audited by: <u>S. M.</u>	Date: <u>09/11/11</u>
Prototype Approval: <u>N/A</u>	Date: <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ <u>AG</u>	<u>MA</u>

8 7 6 5 4 3 2 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 535-15
109129

RELEASED
8/15/12

D3845-1 HAT BIN
(BELL 206 L/L1)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3845-1KIV AND ADD STEEL GRAY P/N D3845-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.22
REV.	DESCRIPTION	BY	DATE

DESIGN	AP	DART AEROSPACE LTD		
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA		
CHECKED	AP	DRAWING NO.	D3845	REV. C
MFG. APPR.	AP			SHEET 1 OF 1
APPROVED	AP	TITLE		SCALE
DE APPR.	AP	HAT BIN (BELL 206 L/L1)		NTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 5.3 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9253 PER DART QSI 022. TRIM PER MOLD

C
C

PART NUMBER	DESCRIPTION
D3845-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
D3845-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

8 7 6 5 4 3 2 1